International Standard 7949

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION•МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ•ORGANISATION INTERNATIONALE DE NORMALISATION

Woodworking machines — Veneer pack edge shears — Nomenclature and acceptance conditions

Machines à bois — Massicots pour paquets de placage — Nomenclature et conditions de réception

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council. They are approved in accordance with ISO procedures requiring at least 75 % approval by the member bodies voting.

International Standard ISO 7949 was prepared by Technical Committee ISO/TC 39, *Machine tools*.

Woodworking machines — Veneer pack edge shears — Nomenclature and acceptance conditions

1 Scope and field of application

This International Standard specifies the nomenclature appropriate to each part of the machine and, with reference to ISO/R 230, both geometrical and practical tests for veneer pack edge shears, and gives the corresponding permissible deviations which apply to machines for general purpose use and normal accuracy.

NOTE — In addition to terms used in two of the three official ISO languages (English and French), this International Standard gives in the annex the equivalent terms in German, Spanish, Italian and Swedish; these have been included at the request of Technical Committee ISO/TC 39 and are published under the responsibility of the member bodies for Germany, F.R. (DIN), Spain (IRANOR), Italy (UNI) and Sweden (SIS). However, only the terms and definitions given in the official languages can be considered as ISO terms and definitions.

This International Standard deals only with the verification of accuracy of the machine. It does not apply to the testing of the running of the machine (vibrations, abnormal noises, stick-slip motion of the components, etc.), nor to its characteristics (speeds, feeds, etc.) which should generally be checked before testing accuracy.

2 Reference

ISO/R 230, *Test code for machine tools.*

3 Preliminary remarks

3.1 In this International Standard all dimensions and permissible deviations are expressed in millimetres.

3.2 To apply this International Standard, reference should be made to ISO/R 230, especially for installation of the machine before testing, the warming up of the main spindle and other moving parts, and description of measuring methods. The measuring instruments shall not permit errors over 1/3 of the checked tolerances.

3.3 The sequence in which the geometrical tests are given is related to the sub-assemblies of the machine and this in no way defines the practical order of testing. In order to make mounting of instruments or gauging easier, tests may be applied in any order.

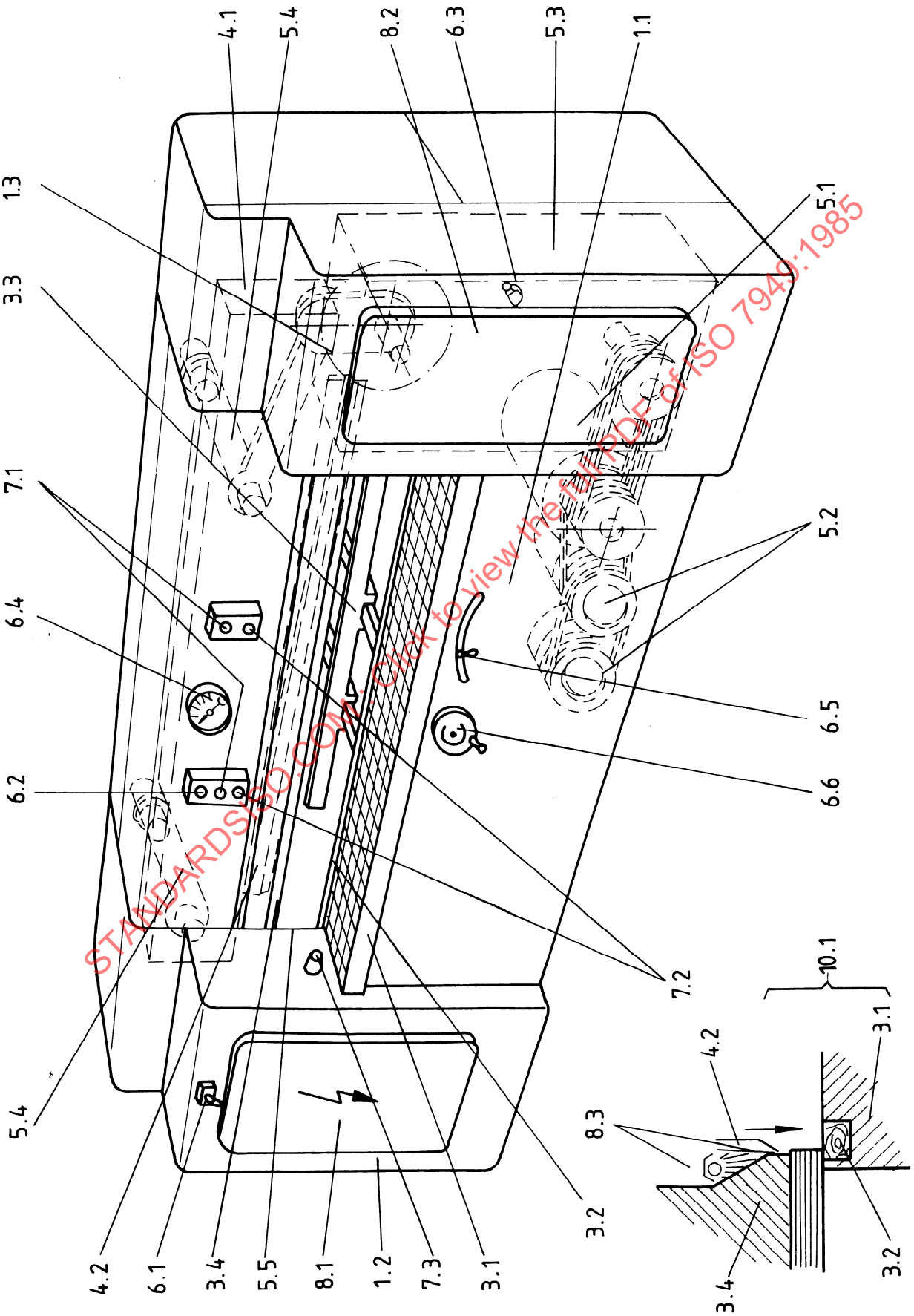
3.4 When inspecting a machine, it is not always possible or necessary to carry out all the tests given in this International Standard.

3.5 It is up to the user to choose, in agreement with the manufacturer, those tests relating to the properties which are of interest to him, but these tests are to be clearly stated when ordering a machine.

3.6 A movement is longitudinal when it takes place in the working direction of the piece.

3.7 When establishing the tolerance for a measuring range different from that given in this International Standard (see 2.311 in ISO/R 230), it should be taken into consideration that the minimum value of the tolerance is 0,01 mm.

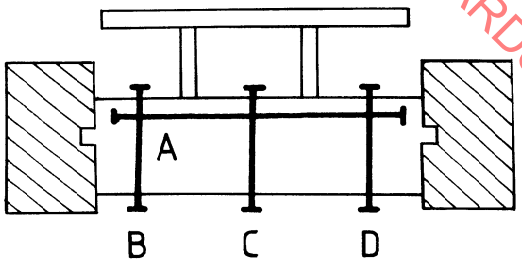
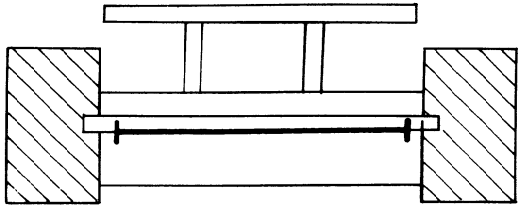
4 Nomenclature

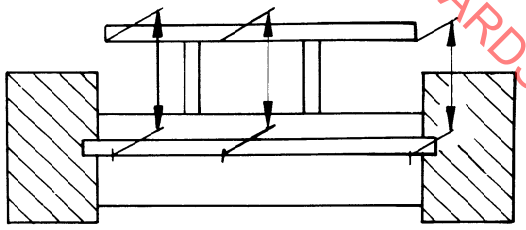
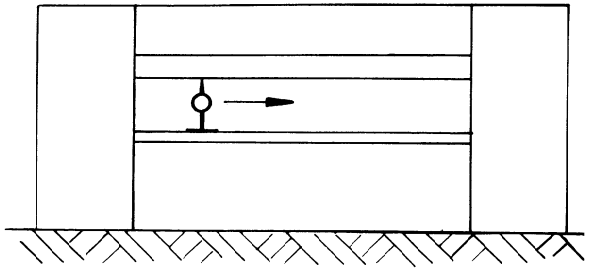


Reference	English	French
	Veneer pack edge shears	**Massicot pour paquets de placage**
1	**Framework**	**Ossature**
1.1	Central body	Bâti central
1.2	Left hand column	Montant gauche
1.3	Right hand column	Montant droit
2	**Feed of workpiece and/or tools**	**Déplacement des pièces et/ou outils**
3	**Workpiece support, clamp and guide**	**Support, maintien et guidage des pièces**
3.1	Table	Table
3.2	Cutting block	Contre-lame d'usure
3.3	Cutting fence	Guide de coupe
3.4	Pressure beam	Barre de compression
4	**Toolholders and tools**	**Porte-outils et outils**
4.1	Knife holder	Porte-couteaux
4.2	Knife	Couteau
5	**Workheads and tool drives**	**Unité de travail et son entraînement**
5.1	Motor	Moteur
5.2	Hydraulic power pack	Réducteur hydraulique
5.3	Gear box	Boîte de vitesses
5.4	Connecting rods	Bielle
5.5	Knife holder slide	Glissière du porte-couteaux
6	**Controls**	**Commandes**
6.1	Main switch	Commutateur général
6.2	Motion beam switch	Commutateur de descente du sommier
6.3	Pressure regulator	Commande de réglage de la pression
6.4	Pressure gauge	Manomètre
6.5	Fence adjustment, coarse	Commande d'approche du guide
6.6	Fence adjustment, fine	Commande de réglage précis du guide
7	**Safety devices** (examples)	**Dispositifs de sécurité** (exemples)
7.1	Two-hand control : pressure pad	Double commande de descente de la barre de compression
7.2	Two-hand control : knife	Double commande de descente des couteaux
7.3	Photo-electric screen cell	Cellule photoélectrique de protection
8	**Miscellaneous**	**Divers**
8.1	Electric enclosure	Armoire électrique
8.2	Main drive enclosure	Armoire des organes mécaniques
8.3	Cut marker beam	Indicateur lumineux de coupe
9	**Free**	**Libre**
10	**Examples of work**	**Exemples de travail**
10.1	Edge shearing of veneer packs	Massicotage d'un paquet de placage

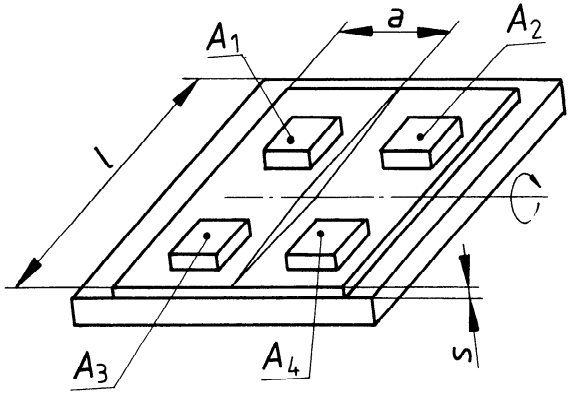
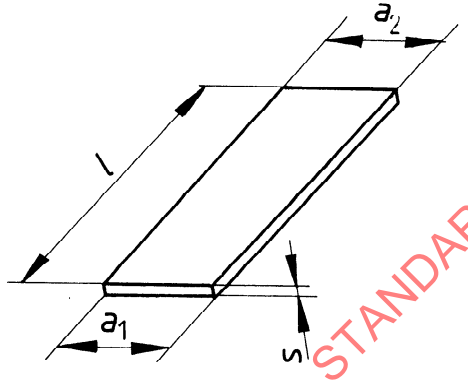
5 Acceptance conditions and permissible deviations

5.1 Geometrical tests

No.	Diagram	Object	Permissible deviation	Measuring instruments	Observations and references in test code ISO/R 230
G1		Checking of flatness of table : *a*) longitudinal straightness; *b*) transverse straightness	*a*) Position A 0,10 for a measuring length of 1000 *b*) Positions B, C, D 0,20	Straightedge and feeler gauges	Clause 5.322
G2		Checking of straightness of knife holder	0,10 for a measuring length of 1000	Straightedge and feeler gauges	Clauses 5.222 and 5.212

No.	Diagram	Object	Permissible deviation	Measuring instruments	Observations and references in test code ISO/R 230
G3		Checking of parallelism of the knife holder to the cutting fence, in maximum position	0,10 per 1 000	Steel gauge and slide gauge	Clause 5.412.2 Checks to be made at several points.
G4		Checking of parallelism of the pressure beam in upper position to the table surface	0,50	Dial gauge	Clause 5.412.2

5.2 Practical tests

No.	Diagram	Nature of test and execution conditions	Permissible deviation	Measuring instruments	Observations and references in test code ISO/R 230
P1		Checking of straightness of two veneer pieces cut from a veneer pack; smooth veneer with the minimum of stress	0,10 for a measuring length of 1000	A flat surface : four weights A_1, A_2, A_3, A_4 Feeler gauges	Clauses 5.212 and 5.222 Test pieces with no local defects a = ⩾ 350 l = working length s = 0,60 to 1,00 Repeat the test after turning one test piece 180°
P2		Checking of parallelism of individual veneer cut	a_1/a_2 0,10 for a measuring length of 1000	Slide gauge	Test piece a = ⩾ 350 l = working length s = ⩾ 1,50

Annex
Equivalent terms

Reference	German	Spanish	Italian	Swedish
	Furnierpaketschneidemaschine	**Cizalla para paquetes de chapa**	**Taglierina per pacchi di impiallacciature**	**Fanérklippmaskin**
1	**Ständer**	**Armazón**	**Intelaiatura**	**Stativkonstruktion**
1.1	Hauptständer	Cuerpo central	Basamento	Huvudstativ
1.2	Ständer, links	Columna izquierda	Montante di sinistra	Vänster pelare
1.3	Ständer, rechts	Columna derecha	Montante di destra	Höger pelare
2	**Vorschub von Werkstück und/oder Werkzeug**	**Desplazamiento de las piezas y/o de las herramientas**	**Spostamento dei pezzi e/o degli utensili**	**Matning av arbetsstycke och/eller verktyg**
3	**Werkstückauflage, -Halterung und -Führung**	**Soporte, sujeción y guía de las piezas**	**Supporto, fissaggio e guida dei pezzi**	**Upplag, hållare och styrning för arbetsstycke**
3.1	Tisch	Mesa	Tavola	Bord
3.2	Schneidleiste	Contra-cuchilla de trabajo	Controlama	Skärlist
3.3	Anschlag	Guía de corte	Guida di taglio	Anslag
3.4	Preßbalken	Barra de compresión o pisón	Barra di pressione	Pressbalk
4	**Werkzeugträger und Werkzeuge**	**Porta-herramienta y herramienta**	**Portautensili ed utensili**	**Verktygshållare och verktyg**
4.1	Messerträger	Porta-cuchilla	Portacoltello	Knivbalk
4.2	Messer	Cuchilla	Coltello	Kniv
5	**Einbauteile und Teile für den Werkzeugantrieb**	**Unidad de trabajo y su transmisión**	**Unità operatrice e suo azionamento**	**Bearbetningsenheter och drivsystem**
5.1	Motor für Messerantrieb	Motor	Motore	Motor
5.2	Hydraulikaggregat	Reductor hidráulico	Gruppo idraulico	Hydraulikaggregat
5.3	Getriebe	Caja de velocidades	Scatola ingranaggi	Växellåda
5.4	Zugstange	Biela	Biella	Vevarmar
5.5	Messerbalkenführung	Guía del porta-cuchilla	Slitta portacoltello	Knivbalksstyrning
6	**Bedienungs- und Überwachungs-organe**	**Mandos**	**Comandi**	**Manöverorgan**
6.1	Hauptschalter für Motor	Commutador general	Interruttore principale	Huvudströmbrytare
6.2	Schalter für Preßbalkenaufwärts-bewegung	Commutador de descenso	Interruttore di comando della barra	Strömbrytare för returrörelse hos pressbalken
6.3	Preßdruckeinstellung	Mando regulador de la presión	Regolatore pressione	Tryckinställning
6.4	Manometer	Manómetro	Manometro	Tryckmätare
6.5	Grobeinstellung des Anschlages	Mando de aproximación de la guía	Comando regolazione approssimativo della guida	Grovinställning av anslaget
6.6	Feineinstellung des Anschlages	Mando de precisión para el reglaje de la guía	Comando regolazione di precisione della guida	Fininställning av anslaget
7	**Sicherheitseinrichtungen** (Beispiele)	**Dispositivos de seguridad** (ejemplos)	**Dispositivi di sicurezza** (esempi)	**Säkerhetsanordningar** (exempel)
7.1	Zweihandschaltung für Balkenabwärts-bewegung	Mando doble de descenso de la barra de compresión	Doppio comando di discesa barra di pressione	Tvåhandsmanöverdon för press-balksrörelse
7.2	Zweihandschaltung für Schnittauslösung	Mando doble para descenso de la cuchilla	Doppio comando di discesa del coltello	Tvåhandsmanöverdon för knivbalksrörelse
7.3	Lichtstrahlsicherung	Célula fotoeléctrica de protección	Cellula fotoelettrica di protezione	Ljusridå
8	**Verschiedenes**	**Varios**	**Varie**	**Diverse**
8.1	Wartungsdeckel für Elektrik	Armario eléctrico	Armadio gruppo elettrico	Elskåp
8.2	Wartungsdeckel für Antrieb	Armario	Armadio organi principali	Transmissionsskydd
8.3	Schnittandeuter mit Lichtstrahl	Luz indicadora de corte	Luce indicatrice di taglio	Snittmarkeringsljus
9	**Frei**	**Libre**	**Libero**	**Vakant**
10	**Arbeitsbeispiele**	**Ejemplos de trabajo**	**Esempi di lavorazione**	**Bearbetningsexempel**
10.1	Beschneiden eines Furnierpaketes	Corte de un paquete de chapa	Taglio di un pacco di impiallacciature	Kantskärning av fanérpaket